

Date: Monday, 6/5/2006 11:01:32 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: AFT STRUT ASSEMBLY
Job Number	: 27415		
Estimate Number	: 11286		
P.O. Number	: NIA	Part Number	: D3437041
This Issue	: 6/5/2006 S.O. No. : NIA	Drawing Number	: D3437 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: NIA Type : SMALL /MED FAB	Drawing Revision	: B
Previous Run	: NIA	Material	: NIA
Written By	: <u>SEE COMMENT BELOW</u>	Due Date	: 6/30/2006 Qty: <u>15</u> Um: Each
Checked & Approved By	: <u>06 06 05</u>		
Comment	: Est. A 05.05.20 New Issue KJ/JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D34371	Foot
-----	--------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 16.0000 Each(s)

Foot

Pick:

Qty	Part Number	Description	Batch
1	D3437-1	Foot	<u>B 27422</u>

2.0	D34373	Clip
-----	--------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 16.0000 Each(s)

Clip

Pick:

Qty	Part Number	Description	Batch
1	D3437-3	Clip	<u>B 23408B</u>

3.0	D343711	Eye Bolt
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 16.0000 Each(s)

Eye Bolt

Pick:

Qty	Part Number	Description	Batch
1	D3437-11	Eye Bolt	<u>B 27423</u>

4.0	MS21083N5	Self Locking Nut
-----	-----------	------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 16.0000 Each(s)

Self Locking Nuts

Pick:

Qty	Part Number	Description	Batch
1	MS21083N5	Self Locking Nut	<u>M 17644 M18535</u>

MS21043-SSB 06/06/29 (15)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Monday, 6/5/2006 11:01:32 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT STRUT ASSEMBLY

Job Number: 27415

Part Number: D3437041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3437

Dwg Rev: B

SB 06/06/29

(15)

6.0

QC4  
A



Inspect work

INSPECT 100% KITS FOR COMPLETENESS



06-06-30

(15)

Comment: ~~INSPECT 100% KITS FOR COMPLETENESS~~

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 83

H.M 06-06-30

(15)

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

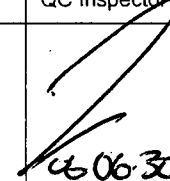
06/07/04

(15)

Job Completion



u 06/07/04

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	
06/06/30	6	QCS req'd. permanent change. to inspect work					 06/06/30	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

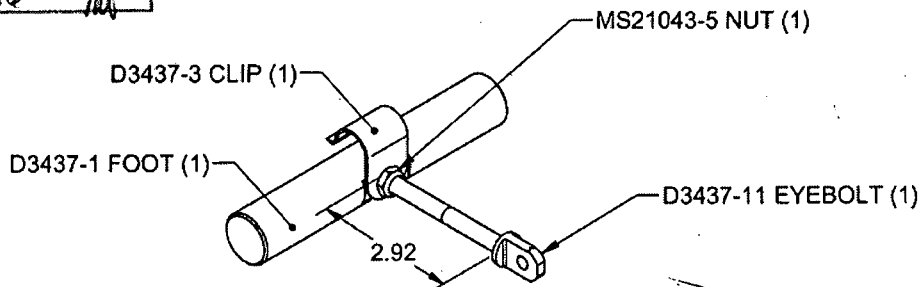
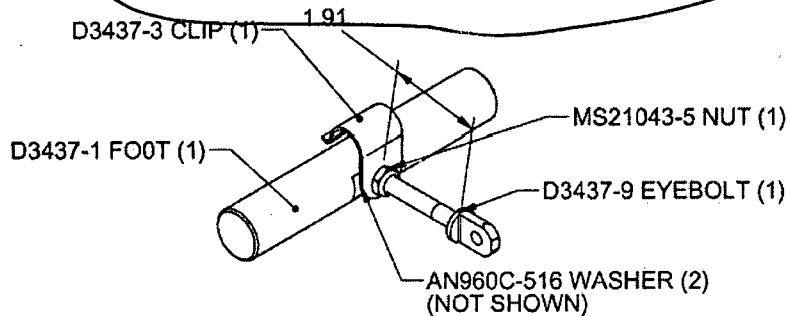
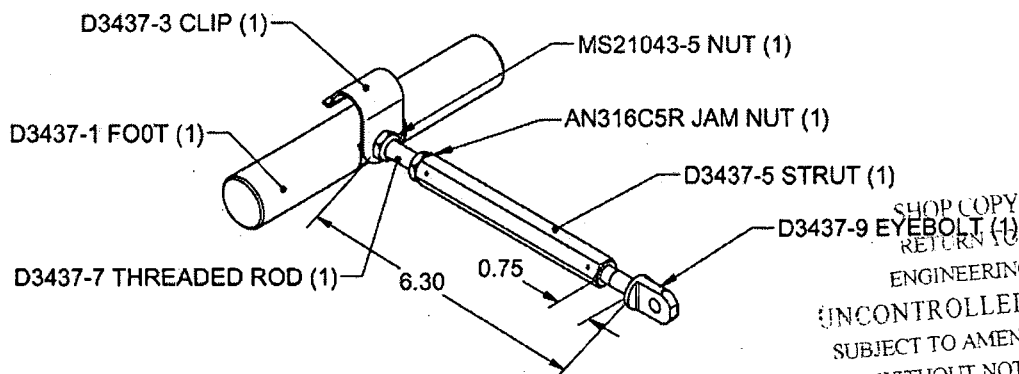
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA:  Date: 06/07/04

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

**DART**

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3437</b>	REV. B SHEET 1 OF 4
DATE <b>05.08.11</b>	TITLE <b>AFT STRUT ASSEMBLY</b>		SCALE 1:2
A	05.04.29	NEW ISSUE	
B	05.08.11	UPDATE D3437-5/-9/-11 DIMENSIONS	

**RELEASED**05.08.16 *[Signature]***D3437-041 AFT STRUT ASSEMBLY****D3437-043 AFT STRUT ASSEMBLY****D3437-045 AFT STRUT ASSEMBLY**

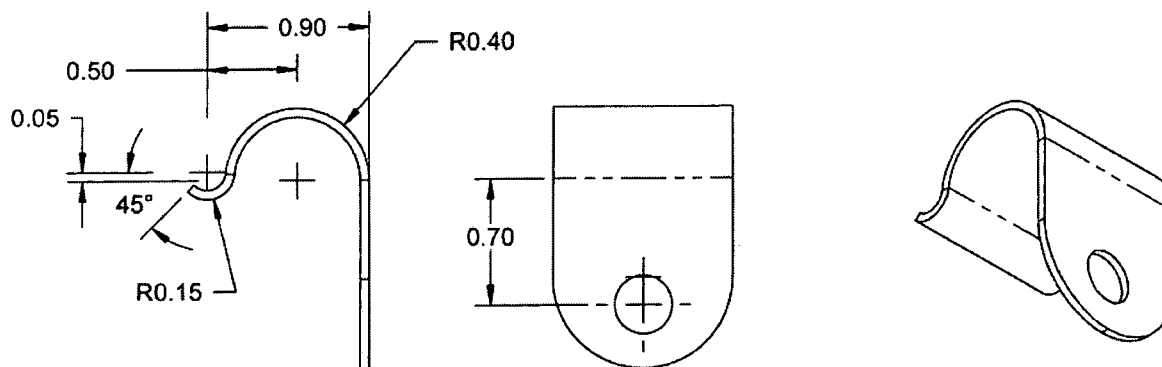
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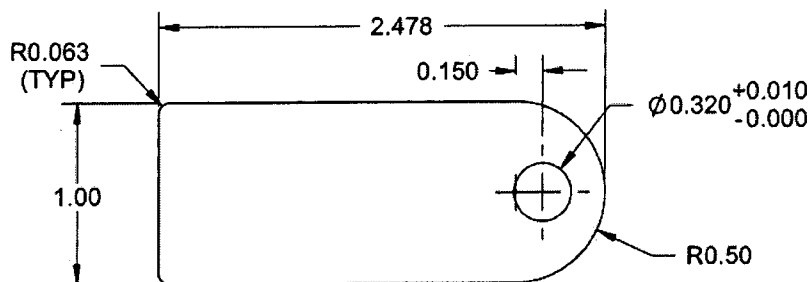
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DATE <b>05.08.11</b>		TITLE <b>AFT STRUT ASSEMBLY</b>	SCALE 1:2

**RELEASED**05.08.16 *[Signature]*

**D3437-3 CLIP**  
**SCALE 1:1**



**D3437-3**  
**FLAT PATTERN**

**D3437-3 CLIP:**

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.050 THICK (REF DART SPEC M304S18GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

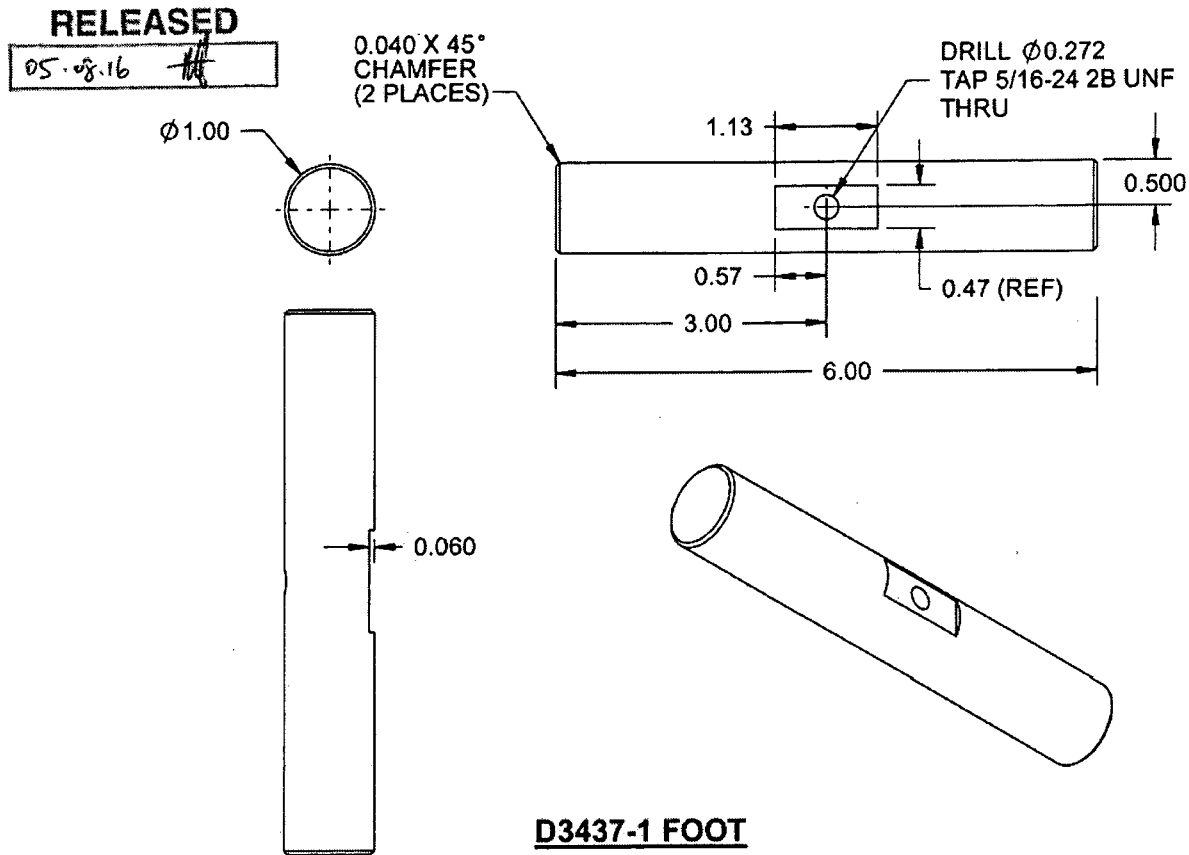
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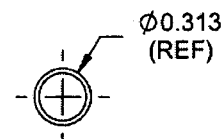
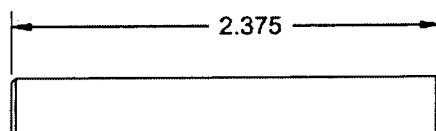
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DATE <b>05.08.11</b>		TITLE <b>AFT STRUT ASSEMBLY</b>	SCALE 1:2



**D3437-1 FOOT**

**D3437-1 FOOT:**

- 1) MATERIAL: 6061-T6 (QQ-A-225/8 OR QQ-A-200/8) ALUMINUM ROUND BAR  
(REF. DART SPEC M6061T6R)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010



**D3437-7 THREADED ROD**

**D3437-7 THREADED ROD:**

- 1) POSSIBLE SUPPLIER: HASKINS-SPAENAU P/N 870-832 18-8 5/16-24 SS THREADED ROD
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

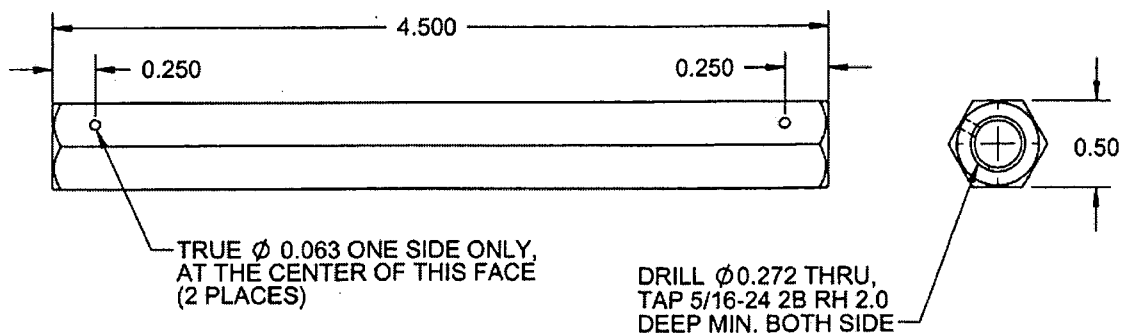
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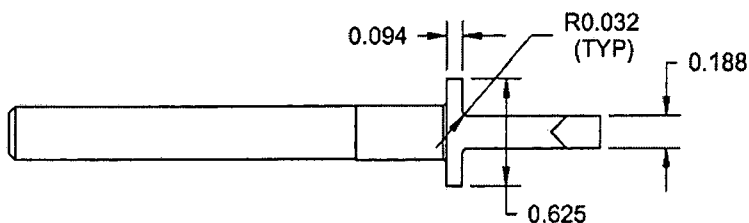


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DATE 05.08.11	TITLE AFT STRUT ASSEMBLY		SCALE 1:2



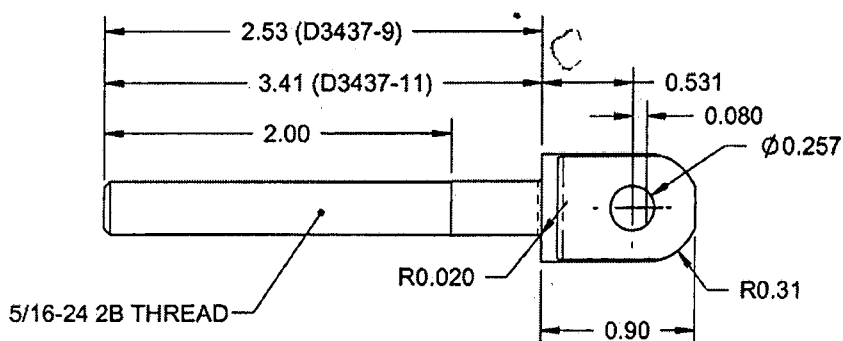
**D3437-5 STRUT:**

- 1) MATERIAL: AISI 303 STAINLESS HEX BAR (DART REF. SPEC M303H0.500)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010



**RELEASED**

05-08-16 *[Signature]*



**D3437-9/-11 EYEBOLT:**

- 1) MATERIAL: AISI 303 STAINLESS ROUND BAR (DART REF. SPEC M303R)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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